

Work Order ID 133235

Wednesday, May 27, 2015 2:46:00 PM

133235

Page 1

Item ID: PB67-43001-75

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Upper Blade Support Ass'Y

Stop *NS2*

Start Date: 5/27/2015 **Start Qty:** 2.00

?

Cust Item ID:

Required Date: 6/5/2015 **Req'd Qty:** 2.00

~

Customer:

Reference:

Approvals: **Process Plan:** JMF

Date: 5-5-21

Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N):

Date:

Stop ***NR2***

[illegible]

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Page 2

Item ID: PB67-43001-75

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Upper Blade Support Ass'Y

Start Date: 5/27/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/5/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3	0.00							
130									
Powdercoat	Memo 11/1/277.	0.00							
Powder Coating	1- put screws in nut plates before to keep thread cleanSTART TIME: 9:10 OVEN TEMPERATURE: 300 FINISH TIME: 9:40.								
140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location <u>W104</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									

2 15-6-14 2338

2 15-26-22 9-86

2 15-26-22 9-89

Order ID 133235

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Page 3

Wednesday, May 27, 2015 2:46:00 PM

Item ID: PB67-43001-75 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Upper Blade Support Ass'Y
 Start Date: 5/27/2015 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 6/5/2015 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ JUN 23 2015

MLJ JUN 23 2015

Picklist Print

Wednesday, May 27, 2015 2:46:00 PM

Page 1

Work Order ID: 133235

133235

Parent Item: PB67-43001-75

PB67-43001-75

Parent Item Name: Upper Blade Support Ass'y

Start Date: 5/27/2015

Required Date: 6/5/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec
10.09.30 per rev C dwg EC verified by:DD

IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3450-1		Manufactured	No			100	Each	4.0000	1	2			

D3450-1

Reinforcement Plate

Location

Loc Qty

Loc Code

Mezz2

4

112993

4

PB67-43001-167

Manufactured

No

100

Each

8.0000

2

4

PB67-43001-167

Side Plate

Location

Loc Qty

Loc Code

Mezz2

8

112995

4

99997

4

PB67-43001-169

Manufactured

No

100

Each

14.0000

1

2

PB67-43001-169

Long Support Plate

Location

Loc Qty

Loc Code

Mezz2

14

112994

14

PB67-43001-171

Manufactured

No

100

Each

87.0000

6

12

PB67-43001-171

Mounting Plate

Location

Loc Qty

Loc Code

Mezz2

87

112996

87

MF 15-5-28

MF 15-5-28

MF 15-5-28

MF 15-5-28

8

7

6

5

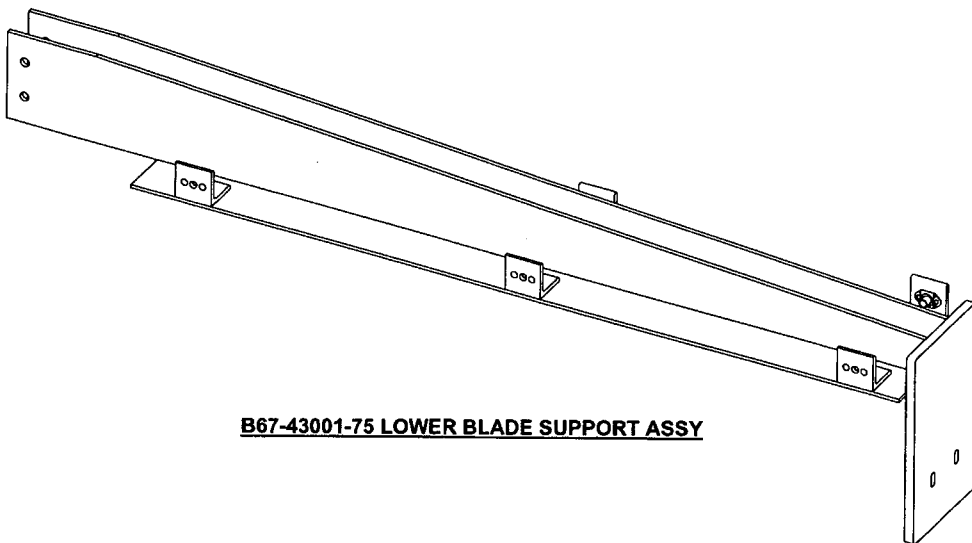
4

3

2

1

ITEM	QTY -75	P/N	DESCRIPTION
1	X	B67-43001-75	LOWER BLADE SUPPORT ASSY
3	2	B67-43001-167	SIDE PLATE
4	1	B67-43001-169	LONG SUPPORT PLATE
5	6	B67-43001-171	MOUNTING PLATE
6	1	D3450-1	REINFORCEMENT PLATE
8	12	MS20426AD3-4	RIVET
9	6	MS21075L3	NUT PLATE



B67-43001-75 LOWER BLADE SUPPORT ASSY

mf
#133235

RELEASED
2010-09-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDTEX" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-75" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.20 lbs
- 8) WELDING: PER DART QSI 004

C		REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION			BY	DATE
DESIGN	RW			DART AEROSPACE LTD	
DRAWN	AS			HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS			DRAWING NO. REV. C	
MFG. APPR.	AS			B67-43001-75 SHEET 1 OF 2	
APPROVED	mf			TITLE SCALE	
DE APPR.	N/A			LOWER BLADE SUPPORT ASSY NTS	
DATE	09.06.26			COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.					

DQA: _____ Date: _____

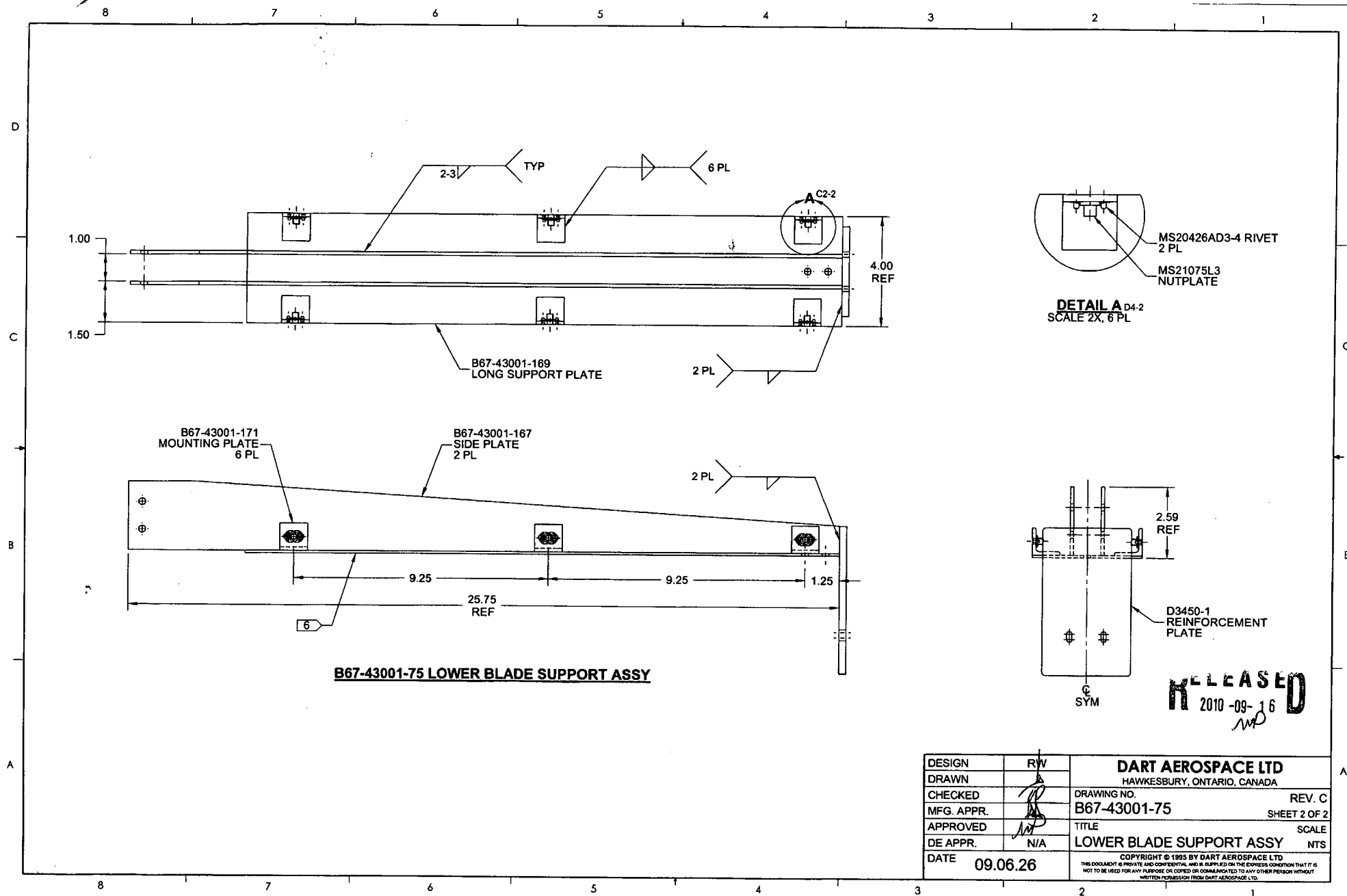


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					



B67-43001-75 LOWER BLADE SUPPORT ASSY

DETAIL A D4-2
SCALE 2X, 6 PL

RELEASED
2010-09-16
MD

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-75	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS
DATE	09.06.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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